

542

175

DART AEROSPACE LTD	Work Order:	24343
Description: Bracket Assembly	Part Number:	D3155-042
RF04.11.29		pB30-23000-12
Drawing: D3155 Rev. A1 c	Qty:	8
		Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler	KJ	05.09.26	8
2	MV	Cut blanks: (2.000" x 1.000") x 6.87" Long Bar Material: 6061-T6/-T651 (QQ-A-200/8 or QQ-A-225/8) (M6061T6B2.000x01.000) Batch: M10745	En	05.10.21	8
3	MV	Machine as per Folio FA315 and Dwg D3155	BC	05.10.27	8
4	QC2	Inspect parts as they come off the CNC machine	BC	05.10.27	8
5	MV	Deburr and Tumble n/a	BC	05.10.27	8
6	QC5 & 8	Inspect work to Step 5	SA	05.10.27	8
7	FP	Chemical Conversion Coat per QSI 005 4.1	FC	05.10.31	8
8	QC3	Inspect Conversion Coat	WJ	05.11.01	8
9	GA	Press fit bushing as per Dwg D3155 Qty Part number Description Batch 2 D3155-3 Bushing 4 018864 28 A 24344	SB	05.11.10	8
10	QC5	Inspect work to Step 9	2	05.11.14	8
11	ST	Identify and Stock Location 88	U	05.11.14	8
12	AC	Cost/part 65.27	545	05.11.18	8
13	DC	Close W/O 64.04 Inspect Level 21	D	05.11.18	8

Rev	Date	Change	Revised By	Approved
A	02.05.30	New Issue	NG	
B	03.02.03	Reformat	KJ/RF	

RELEASED
03.02.04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

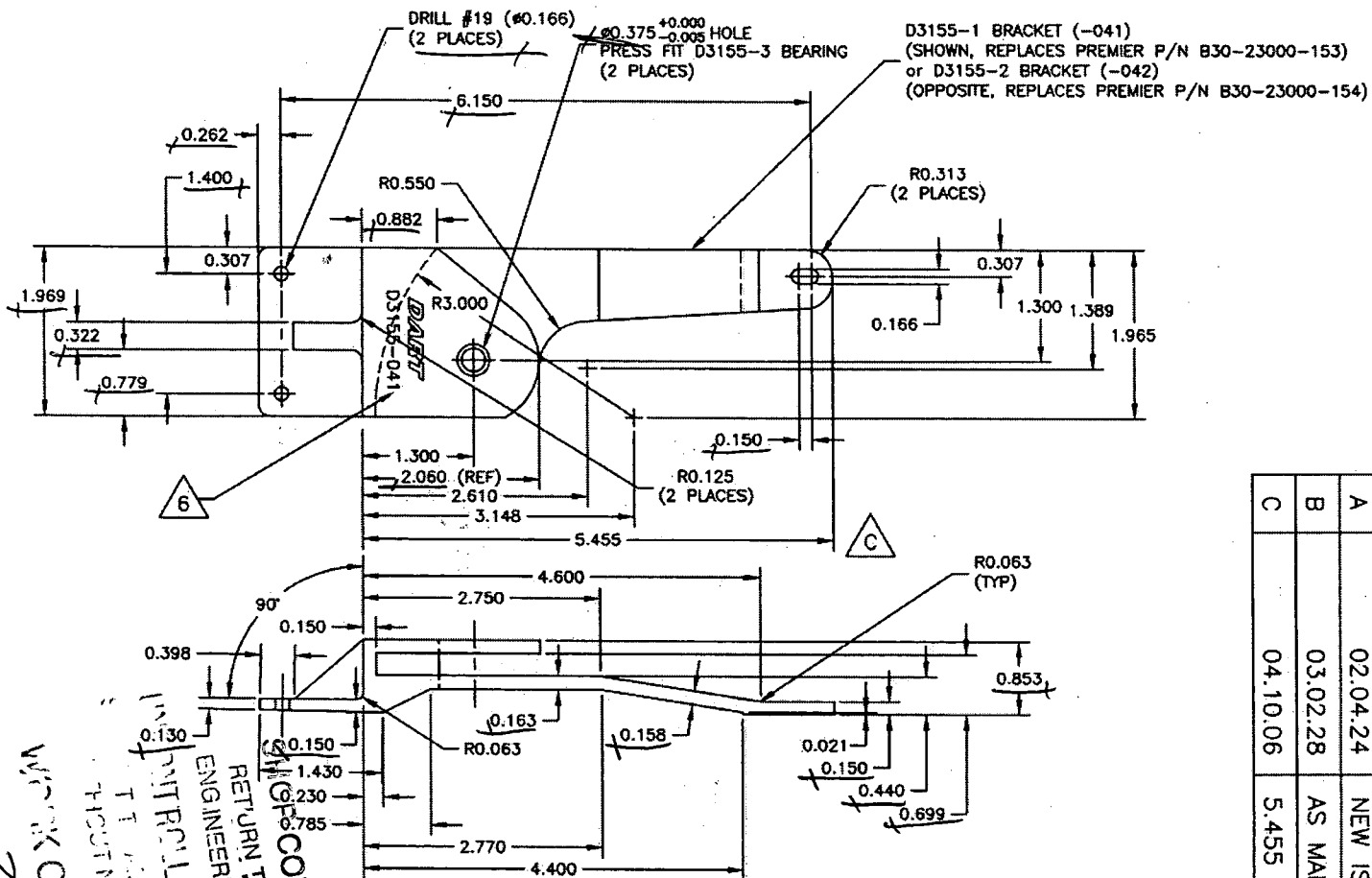
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 05/14/18

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

QA COPY ISSUED

DESIGN	DRAWN BY	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3155	REV. C SHEET 1 OF 2
DATE		TITLE SCALE	
04.10.06		BRACKET ASSEMBLY 1:2	
A	02.04.24	NEW ISSUE	
B	03.02.28	AS MANUFACTURED	
C	04.10.06	5.455 WAS 5.550	



03155-041 BRACKET ASSEMBLY

(SHOWN, REPLACES PREMIER P/N B30-23000-11)

D3155-042 BRACKET ASSEMBLY

(OPPOSITE, REPLACES PREMIER P/N B30-23000-12)

D3155-1/-2 BRACKET

- 1) MATERIAL: 6061-T6/-T651 (QQ-A-200/8 OR QQ-A-225/8) BAR
(REF DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 6) ENGRAVE DART P/N & LOGO AS SHOWN

04.11.23

RETURN TO
ENGINEERING
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ATTACHMENT
THOUT NOTICE
WORK ORDER
NO. 24343

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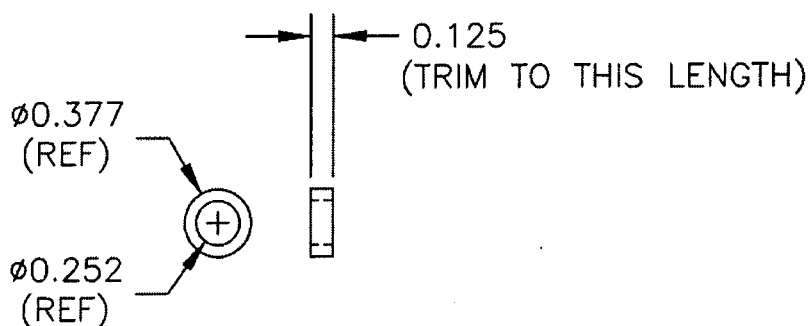
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DESIGN #	DRAWN BY #	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3155	REV. C SHEET 2 OF 2
DATE 04.10.06		TITLE BRACKET ASSEMBLY	SCALE 1:1

RELEASED
04.11.23 #



D3155-3 BUSHING

- 1) MAKE FROM P/N SBS-3-3 (SOLID BAR) OR SS-812-20 (TUBING)
POSSIBLE SUPPLIER: SYMMCO
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Sep 26, 2005
10:48 am

Work Order No : 0024343
Project Name : D3155-042
Project For : WK542
Work Order Type : Main
Main WO Number :
House Part Number : D3155-042
Description : Bracket Assembly
Manufactured : Yes
Amount Req'd : 8
Amount Done : 0
Start Date : 09-26-05
Est Finish Date : 10-15-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Mark Up : 0.000%
Actual Mark Up : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00

DART AEROSPACE LTD		Work Order: 24343
Description: Bracket assembly		Part Number: D3155-042
Inspection Dwg:	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.262"		.261"	✓			
1.400"		1.398"	✓			
1.969"		1.969"	✓			
.322"		.325"	✓			
.779"		.784"	✓			
2.060"	REF	2.062"	✓			
.882"		.882"	✓			
6.150"		6.151"	✓			
∅.166"		∅.166"	✓			
∅.375"	+0.000 -0.005	.375"	✓			
.150"		.155"	✓			
.699"		.701"	✓			
.130"		.130	✓			
.150"		.154	✓			
.158"		.163	✓			
.150"		.156	✓			
.440"		.446	✓			
.699"		.701	✓			
.853"		.849	✓			
.163"		.165	✓			
.307"		.304	✓			

Measured by: MR	Audited by: SD	Prototype Approval:
Date: 05/10/26	Date: 05.10.27	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/RF	

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Nov 08, 2005
11:44 am

Work Order No : 0024343
Project Name : D3155-042
Project For : WK542
Work Order Type : Main
Main WO Number :
House Part Number : D3155-042
Description : Bracket Assembly
Manufactured : Yes
Amount Req'd : 8
Amount Done : 0
Start Date : 09-26-05
Est Finish Date : 10-15-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Margin : 0.000%
Actual Margin : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	19.00	100.00		
Production Cost :	0.00	450.04	100.00	0.00	450.04
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	18.50	100.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	450.04	100.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	450.04			

Labour Hrs/Amount Done : Estimated 0.00 Actual 0.00
Profits/(Loss) : 0.00 (-450.04)

MIS 01/13
u
11-13

Date: Monday, 14/11/2005 8:39:53 AM
 User: Alba Panzuto

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BRACKET ASSEMBLY
Job Number : 24343	
Estimate Number : 10397	
P.O. Number :	Part Number : D3155042
This Issue : 14/11/2005 S.O. No. :	Drawing Number : D3155 REV C
Prsht Rev. : NC	Project Number :
First Issue : / / Type : R & D SM/MED FAB	Drawing Revision : C
Previous Run :	Material :
Written By :	Due Date : 30/11/2005 Qty: 8 Um: Each
Checked & Approved By :	
Comment : Est B 03.02.03 Reformat KJ/RF	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6B1000X02000	6061-T6 Bar 1.0" x 2.0"
2.0	BAND SAW	BAND SAW
Comment: BAND SAW Cut blanks: (2.000" x 1.000") x 6.87" Long Bar		
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
Comment: HAAS CNC VERTICAL MACHINING #1 1-Machine as per Folio FA315 and Dwg D3155 2-Deburr and Tumble		
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
Comment: INSPECT PARTS AS THEY COME OFF MACHINE		
5.0	QC8	SECOND CHECK
Comment: SECOND CHECK		
6.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1		

Date: Monday, 14/11/2005 8:39:53 AM
User: Alba Panzuto

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET ASSEMBLY

Job Number: 24343

Part Number: D3155042

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

8.0

D3155042

Bracket Assembly

9.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
Press fit bushing as per Dwg D3155

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: _____

12.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL
Inspection Level 21

Job Completion

